

Date: Thursday, 3/23/2006 11:10:53 AM
User: COSS systems

Process Sheet

Duplicate 2
Spit

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 25510 *2*
Estimate Number : 11064
P.O. Number : *N/A*
This Issue : 3/23/2006 S.O. No. : *N/A*
Prsht Rev. : NC
First Issue : 1/16/2006 Type : PURCHASED PARTS
Previous Run :
Written By : *SEE COMMENT BELOW*
Checked & Approved By : *SC*
Comment : Est. D 01.06.05 New process EC

Drawing Name : REPLACEMENT WINDOW
Part Number : D2942
Drawing Number : D2942 REV C
Project Number : N/A
Drawing Revision : C
Material : *N/A*
Due Date : 1/31/2006 Qty: 20 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2958 Window



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Window

Pick:

Qty Part Number Description Batch

1 D2958 Window *(8) B 23509 (6) B 21729*

(20)

2.0 D2956 Window Frame



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Window Frame

Pick:

Qty Part Number Description Batch

1 D2956 Window Frame *B 23507*

(20)

3.0 D2126 Seal



Comment: Qty.: 5.6250 f(s)/Unit Total : 112.5000 f(s)

Seal

Pick:

Qty Part Number Description Batch

1 D2126 (67.0") Seal *B 24668*

JAD 06:03:22 (15)

4.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2942

JB 06/03/23 (15)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/23/2006 11:10:53 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT WINDOW

Job Number: 25510

Part Number: D2942

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST375

C Log 103/27

(14)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/03/28

Job Completion



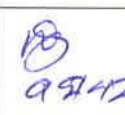
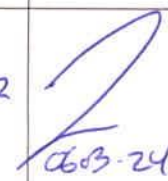

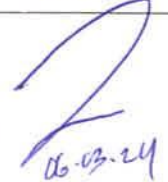

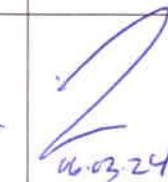


u 06-03-28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: N/A PAR #: N/A Fault Category: NCR022 NCR: Yes No DQA: ND Date: 06/03/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-03-24	4	1 window failed with scratch 1" long.	 06/03/24	Scrap window and re stock frame and seal. No more windows to replace it		 06-03-24	 06/03/24	 06-03-24
06-03-24	4	7 windows scratched from trimming and ASS'y	 06/03/24	Scrap and destroy		 06-03-24	 06/03/24	 06-03-24

NOTE: Date & initial all entries

Process Sheet

Split

HELICOPTER Services

Drawing Name : REPLACE WINDOW

S.O. No. :

Part Number : D2942

Drawing Number : D2942 RE

Project Number : N/A

Type : PURCHASED

Drawing Revision :

Material :

Due Date :

Qty:

20 Unit

Each

Est. : 01.06.05 New product



Machine Operation:

Description :



Machine Op. 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Window

Part Number

Description

Batch

Window

8

B23509

B21724

6

15

Window Frame



Machine Op. 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Window Frame

Part Number

Description

Batch

Window Frame

B23507

~~B21724~~
~~B23509~~

15

Seal



Machine Op. 562500 Each(s)/Unit Total: 112.5000 (s)

Seal

Part Number

Description

Batch

D2128 (67.0°)

Seal

B2128

SAD

06.03.22

15

SMALL & MEDIUM FAB RESOURCE 1



SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2942

SB 06/03/22

15

Process Sheet

Helicopters Services

Drawing Name: REPLACEMENT WINDOW

Part Number: D2942



Description:

INSPECT WORK TO CURRENT STEP



Feb 103 22 5

INSPECT WORK TO CURRENT STEP

PACKAGING RESOURCE #1



PACKAGING RESOURCE #1

Quantity: 500

U.S. 103

Feb 103 122 (5)

DOCUMENT CONTROL



DOCUMENT CONTROL

Quantity: 100

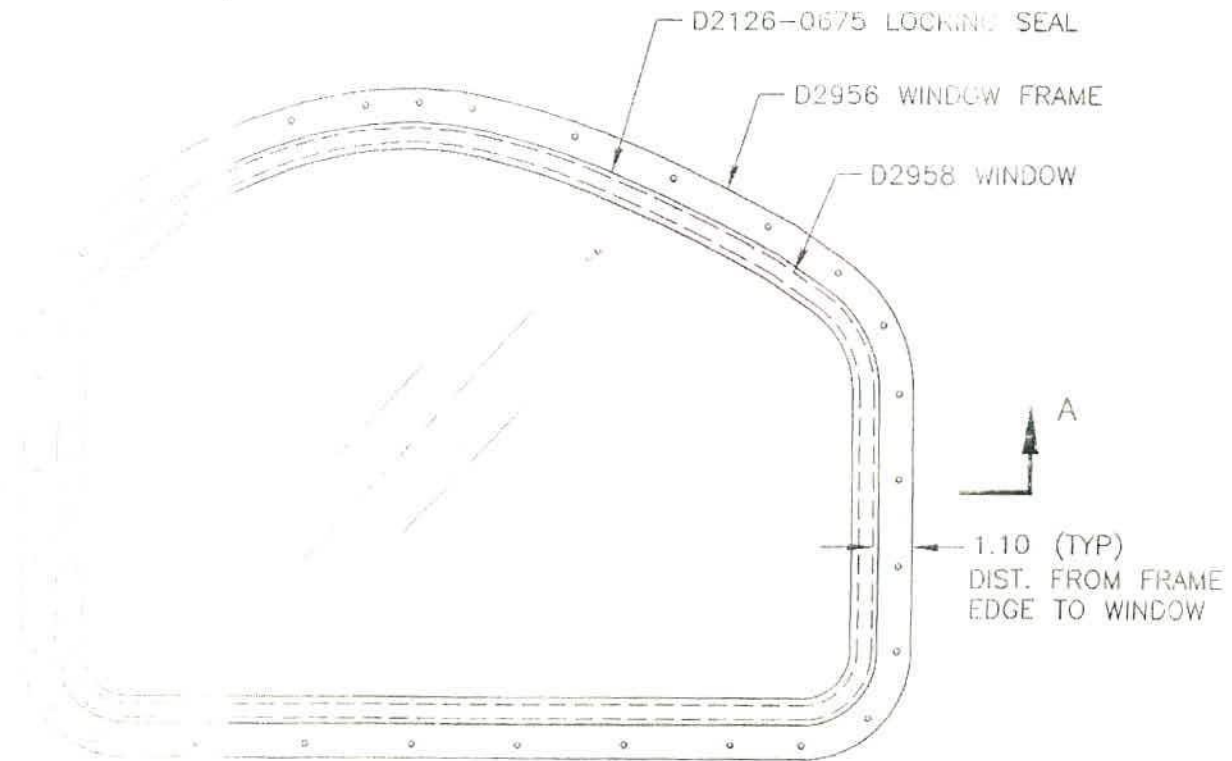


U 06-03-23



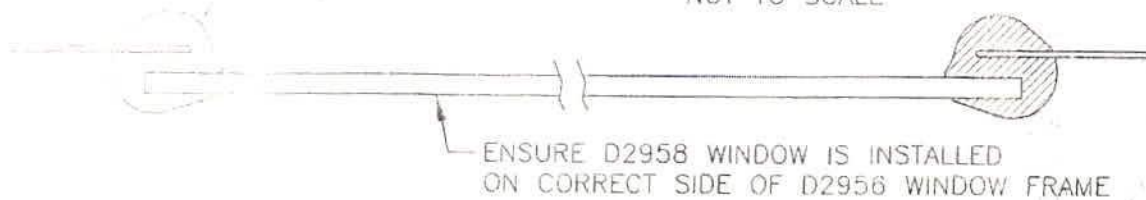
DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. C
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	APPROVED	CP	DRAWING NO. D2942	SHEET 1 OF 1
DATE	01.05.31			TITLE	SCALE
				REPLACEMENT WINDOW	1:1
A	00.01.20			NEW ISSUE	
B	00.02.23			CHANGED FROM RIBET TO SCREW; NOW SEALED ON EDGE ONLY (NCR 407)	
C	01.05.31			WINDOW NOW INSTALLED WITH SEAL	



D2126-0675 LOCKING SEAL
(REF)

SECTION A-A
NOT TO SCALE



ALL DIMENSIONS ARE IN INCHES
UNLESS OTHERWISE NOTED PER DART QSI 018 UNLESS OTHERWISE NOTED

23510

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